

Work Order ID 78904

78904

Page 1

January-17-12 11:52:58 AM

Item ID: D2857-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge Bracket
 Start Date: 17/01/2012 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: M.C.J. Date: 12/01/17 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2857	Rev C								

100 0.00
100 BAND SAW
 Bandsaw Memo 0.00
 Jeaspa Bandsaw Cut blanks 4.425"

RT 12-03-08 24

110 0.00
110 HAAS CNC VERTICAL MACHINING #1
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 1-Machine per folio FA940
 FOLIO REV: AA
 DWG REV: C
 2-Deburr any rough edges

24 12-3-10 24 4

120 0.00
120 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

24 12-3-10 24 4

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

D.A 12/03/12

24 0

24 x 12/03/12

24 12/03/12

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
160	<i>M120202</i>								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>10:25</i> OVEN TEMPERATURE:								
	<i>300</i> FINISH TIME: <i>10:55</i>								

170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									

24X of M-12/03/14

180	Identify as per dwg & Stock Location: <i>019</i>	0.00							
180									
Packaging	Memo	0.00							
Packaging									

24X 3/21 (24)

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N900040100

Setup Start *NS1*

Stop ***NS2***

24

Cust Item ID:

24

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------------	---------------	------------------	----------------

0.00

190

QC

Memo

0.00

Quality Control

Qty	Qty	Number	Stamp
	12	13/21	MF 12-03-2

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Picklist Print

January-17-12 11:53:01 AM

Page 1

Work Order ID: 78904

78904

Parent Item: D2857-2

D2857-2

Parent Item Name: Hinge Bracket

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP C 00.06.22 Removed P/O for powder coatEC
IPP D 06.03.30 Added level 8 EC IPP Rev:E 11.01.06 as
per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	39.6026	0.37	9.347368			

M6061T6B2 000X01 250

6061-T6 Bar 2.00 x 1.25

**

25 12-03-08

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT009	39.60263158	
114899	4.15263158	
116623	2.15	
119136	33.3	

x 9.347368

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DART AEROSPACE LTD		Work Order:	78904
Description: Hinge Bracket		Part Number:	D2857-2
Inspection Dwg: D2857	Rev: B	12-01-17	
		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.300	/			
4.000	+/-0.010	4.001	/			
0.340	+/-0.010	.341	/			
1.110	+/-0.005	1.110	/			
1.790	+/-0.010	1.790	/			
1.320	+/-0.005	1.320	/			
2.000	+/-0.010	2.002	/			
0.340	+/-0.010	.340	/			
0.447	+/-0.010	.445	/			
Ø0.171	+0.005/-0.000	.171	/			
0.147	+/-0.010	.143	/			
0.376	+/-0.010	.378	/			
0.126	+/-0.010	.127	/			
0.063	+/-0.010	.063	/			
Ø0.166	+0.005/-0.000	.166	/			
0.911	+/-0.010	.915	/			
0.600	+/-0.010	.599	/			
0.125	+/-0.010	.125	/			
0.150	+/-0.010	.150	/			

Measured by: [Signature]	Audited by: BA	Prototype Approval:	N/A
Date: 12-3-10	Date: 12/03/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	[Signature]

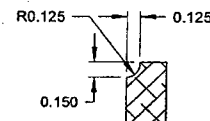
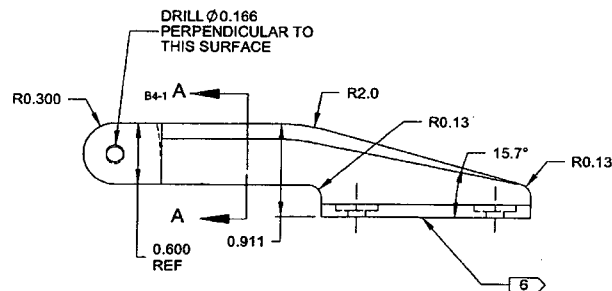
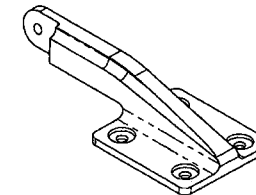
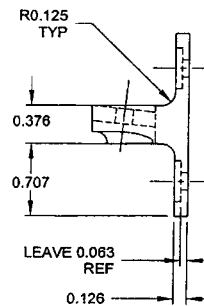
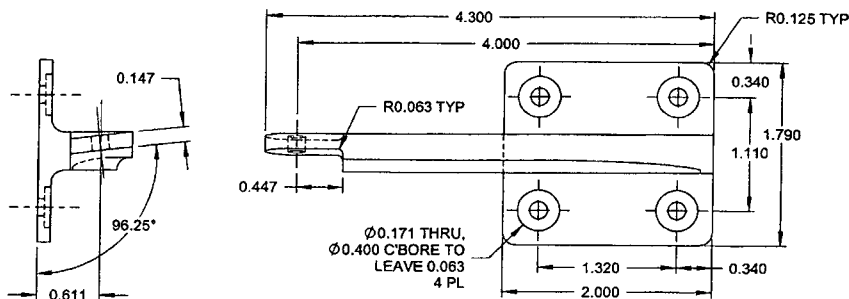
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B7-1 **SECTION A-A**

D2857-1 HINGE BRACKET

SHG 001
R 001
DART AEROSPACE LTD
UNCONTROLLED COPY
SUBJECT TO REVISIONS
W/OUT NOTICE

NO 78904 R 4.C.5
12/01/17

RELEASED
2010-11-26

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D2857-1" PER DART QSI 044 6.1(FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 0.11 lbs

C	REFORMAT DWG, IDENTIFICATION BY MARKER WAS ENGRAVING (A8-1), REF PAR 10-040	CP	10.09.13
B	ADD THICKNESS, REDRAW W/ SOLIDWORKS	LE	06.08.28
A	NEW ISSUE	KE	98.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DP		
CHECKED	DP	DRAWING NO.	REV. C
MFG. APPR.	DP	D2857	SHEET 1 OF 2
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	HINGE BRACKET	NTS
DATE	10.09.13	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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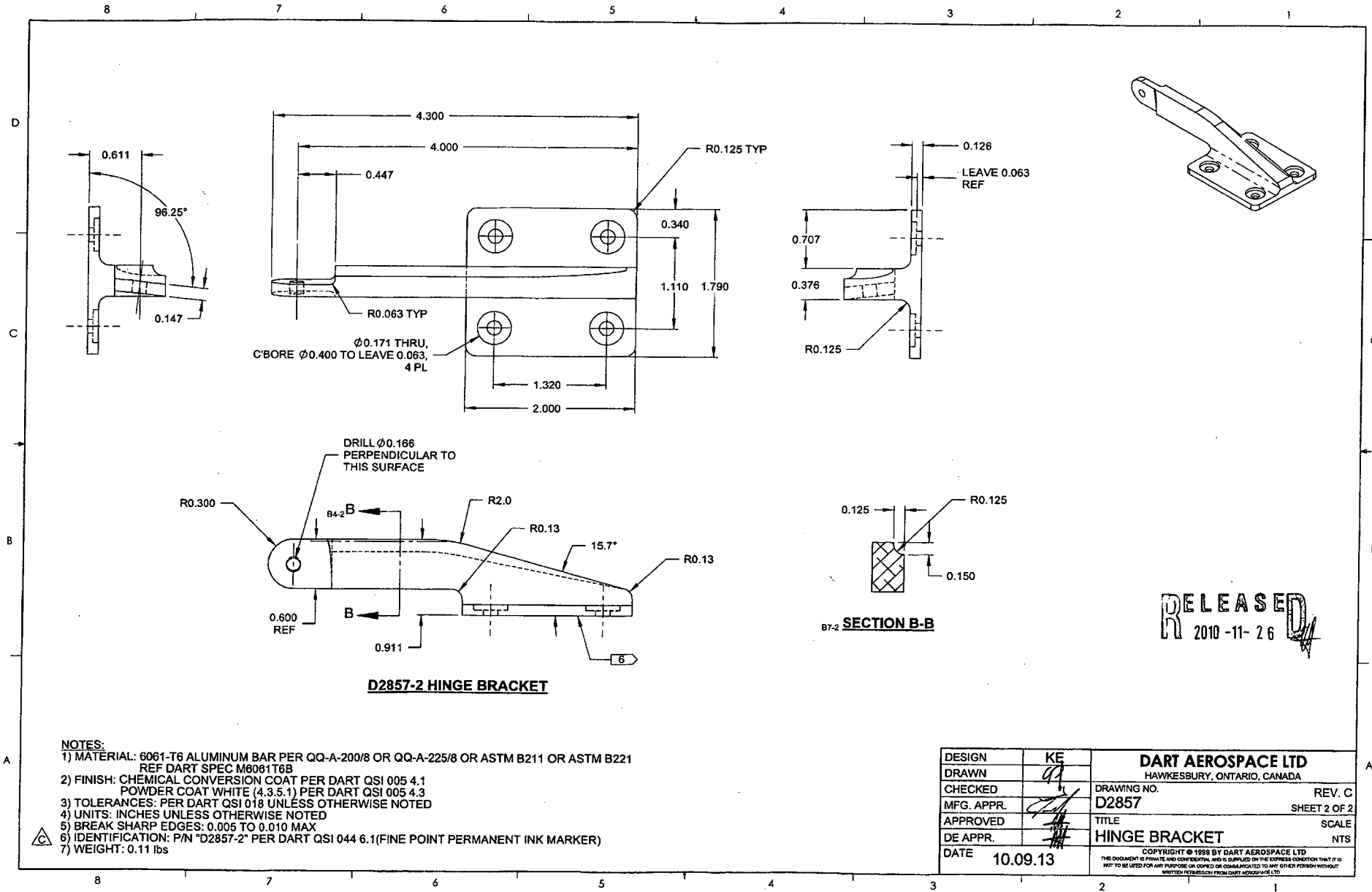
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